

66869817

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE

24" BARREL 7.62 NATO

WITH BIPOD

proof of purchase



owner registration sticker



BM FORM

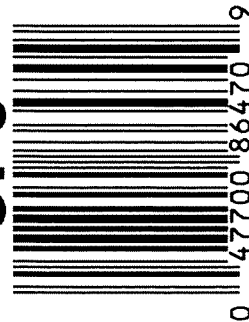
ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6869817

UPC



GUN SERIAL # G 6869817

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-14-09	SP
430	ASSEMBLE TO STOCK		8-15-09	SP
440	PROOF		8-14-09	SP
460	CHECK HEADSPACE		8-14-09	SP
470	DIS-ASSEMBLE ACTION		8-14-09	SP
472	SERIALIZE BOLT HANDLE		8-15-09	RTZ
480	MAGNAFLUX BBL ACTION		8/19/09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/19/09	OWO
510	DRILL AND TAP SIGHT HOLES		8-17-09	SP
520	GOFF BLAST BBL / REC		8/21/09	OWO
540	APPLY COATINGS (BARREL ACTION)		8/24	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	8-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-26-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

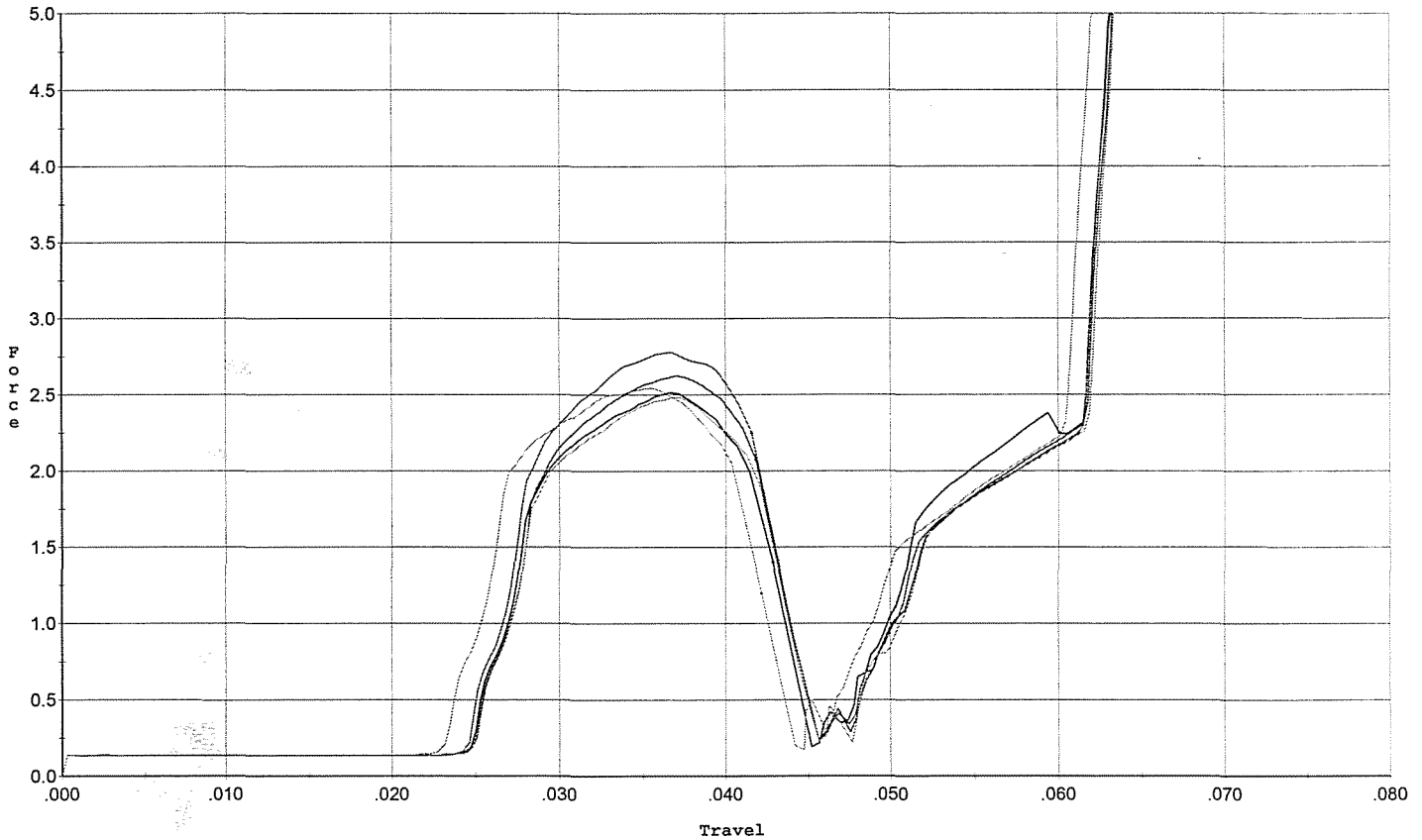
560	F) SAFETY ON FORCE	172 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	8/19/09	RB
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>6°</u> <u>6°</u> <u>6°</u>	8/19/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	8/19/09	RB
	J) ASSEMBLE STOCK			8/26/09	RTZ
	K) ASSEMBLE SWIVEL STUDS			8/19/09	RB
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	8/27/09	LPD
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			8/27/09	RP
670	FINAL INSPECTION A) HEADSPACE			8/29/09	RB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.59</u> <u>2.63</u> <u>2.58</u> <u>2.67</u>	8/28/09	RB
	C) FUNCTION			8/29/09	RB
690	PACK			8/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lb



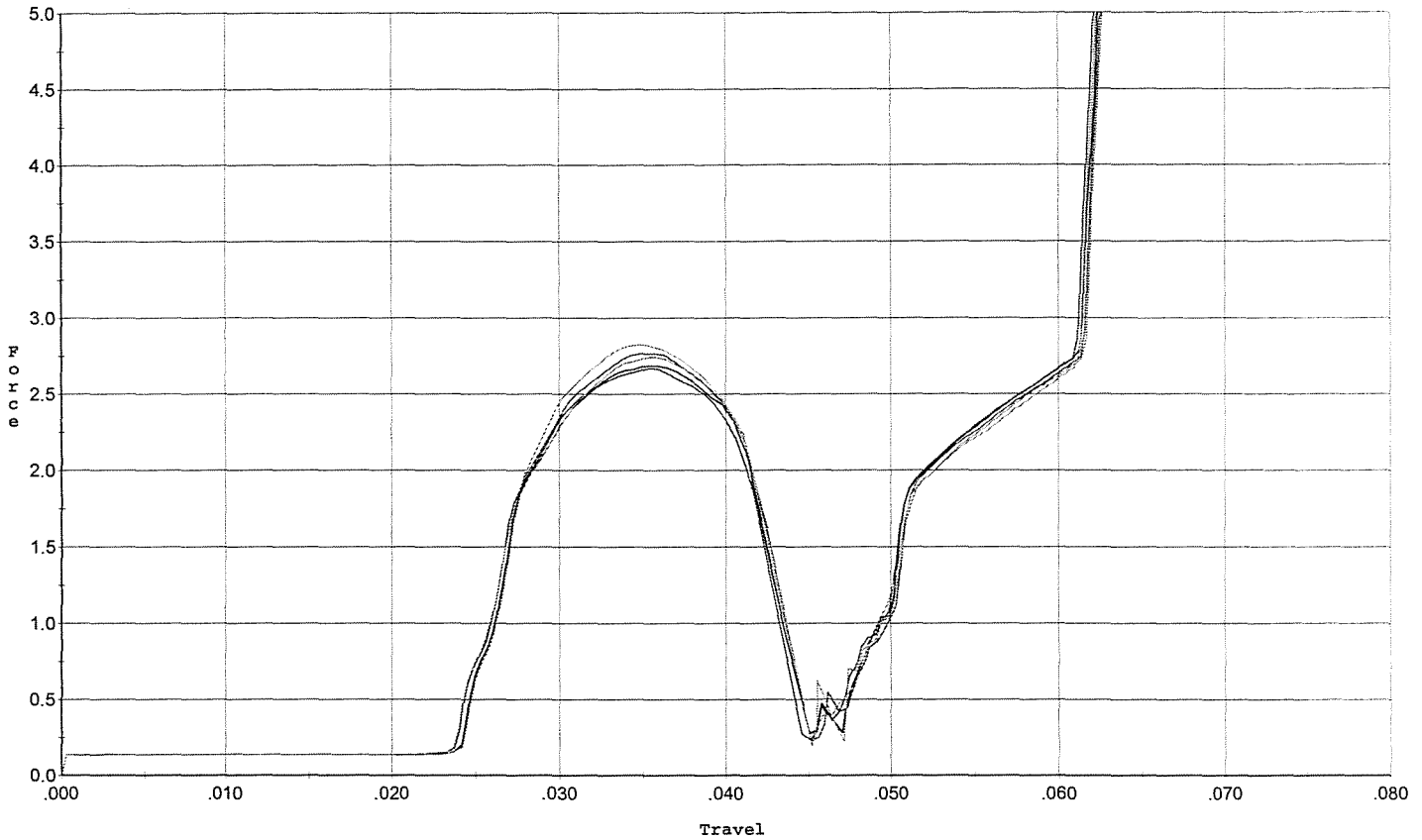
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.042	0.025	0.027	0.040		Set Trigger
2	2.516	0.043	0.025	0.027	0.039		Set Trigger
3	2.780	0.042	0.025	0.027	0.042		Set Trigger
4	2.484	0.042	0.025	0.027	0.038		Set Trigger
5	2.545	0.042	0.023	0.026	0.041		Set Trigger

A-259

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



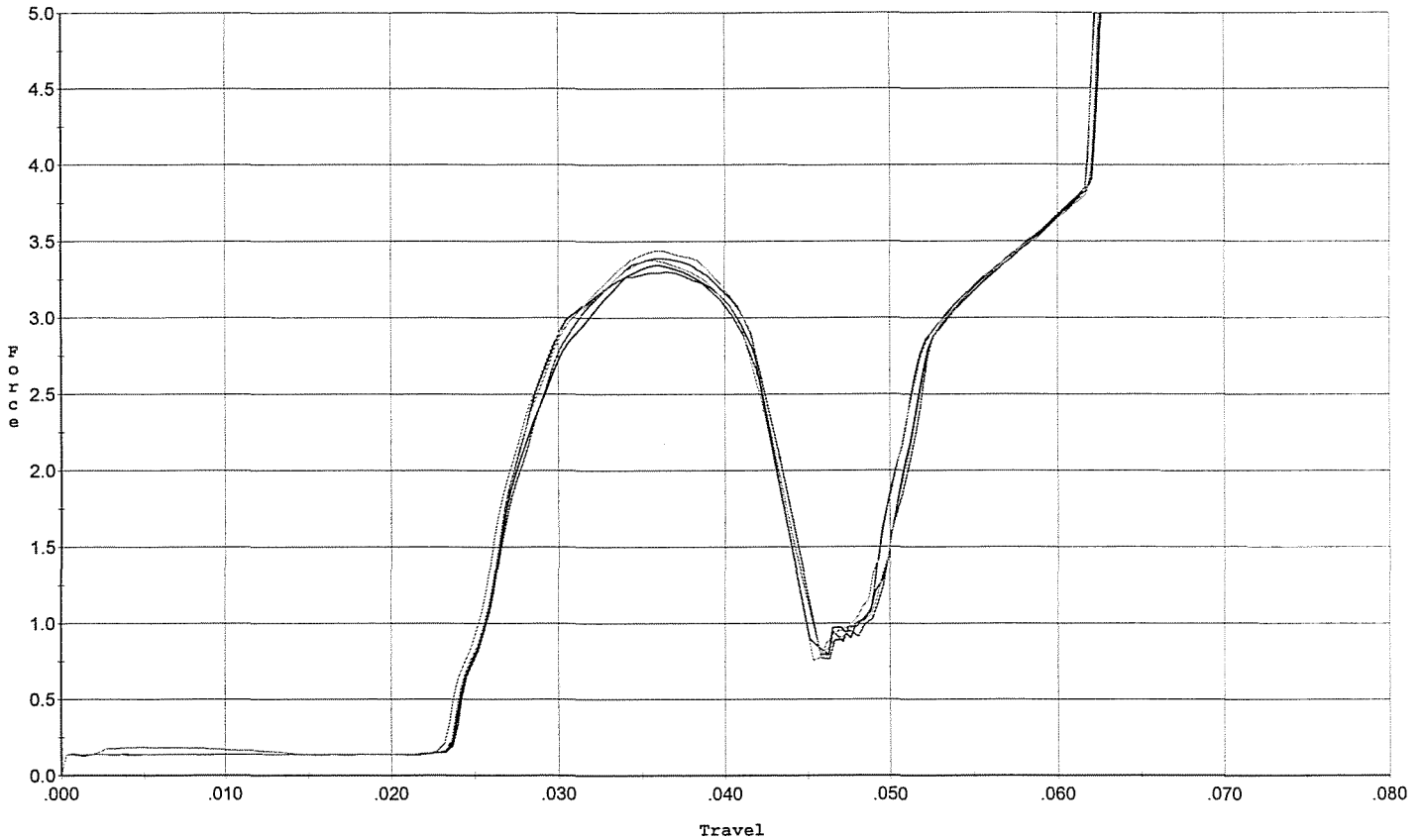
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.670	0.042	0.024	0.026	0.041		Set Trigger
2	2.688	0.041	0.024	0.026	0.041		Set Trigger
3	2.765	0.043	0.024	0.026	0.043		Set Trigger
4	2.825	0.041	0.024	0.026	0.043		Set Trigger
5	2.742	0.043	0.025	0.026	0.043		Set Trigger

A-2-73

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



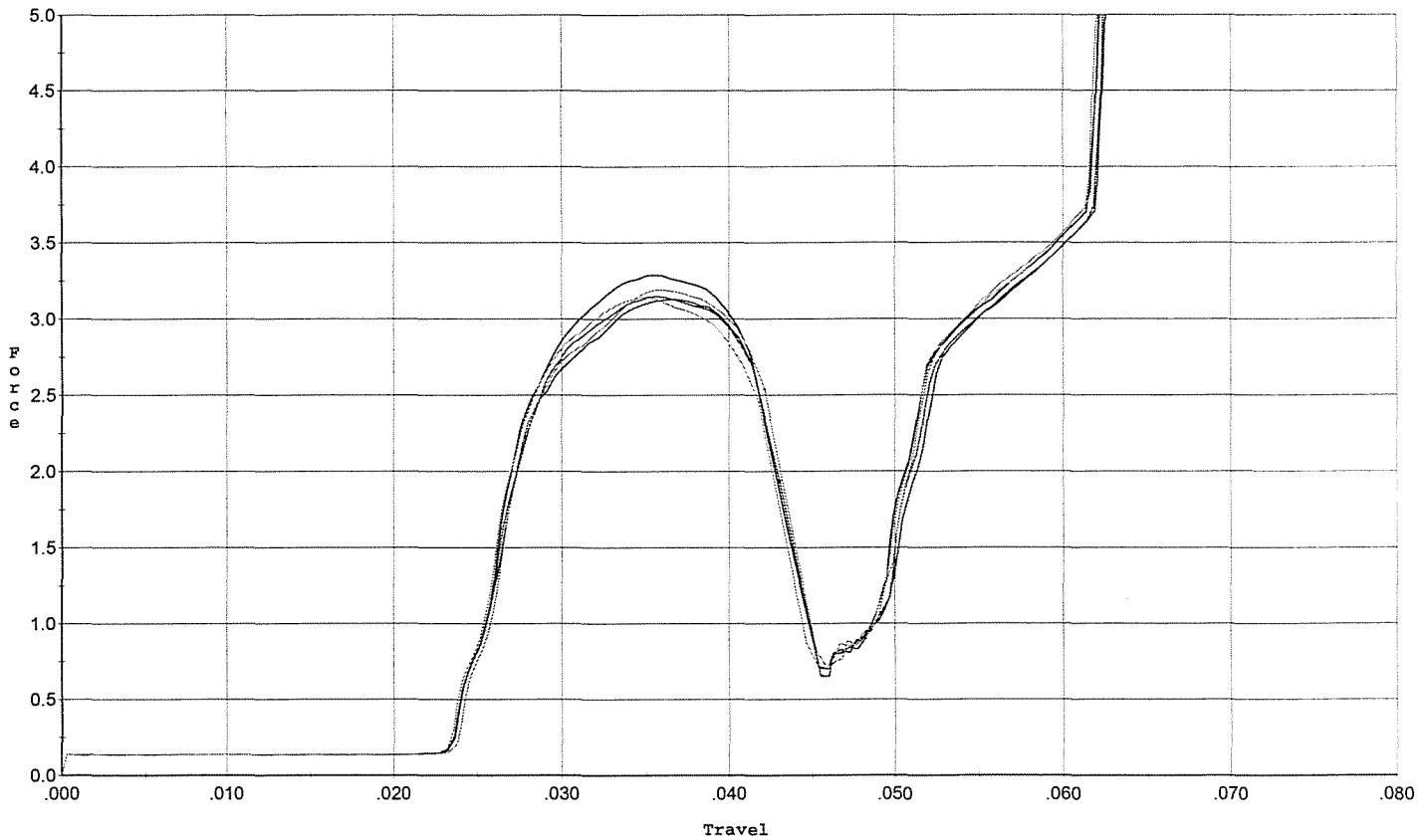
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.299	0.042	0.024	0.025	0.052		Set Trigger
2	3.346	0.042	0.024	0.025	0.052		Set Trigger
3	3.391	0.043	0.024	0.025	0.054		Set Trigger
4	3.376	0.042	0.023	0.025	0.054		Set Trigger
5	3.440	0.042	0.024	0.025	0.053		Set Trigger

A.3-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- .75 lb



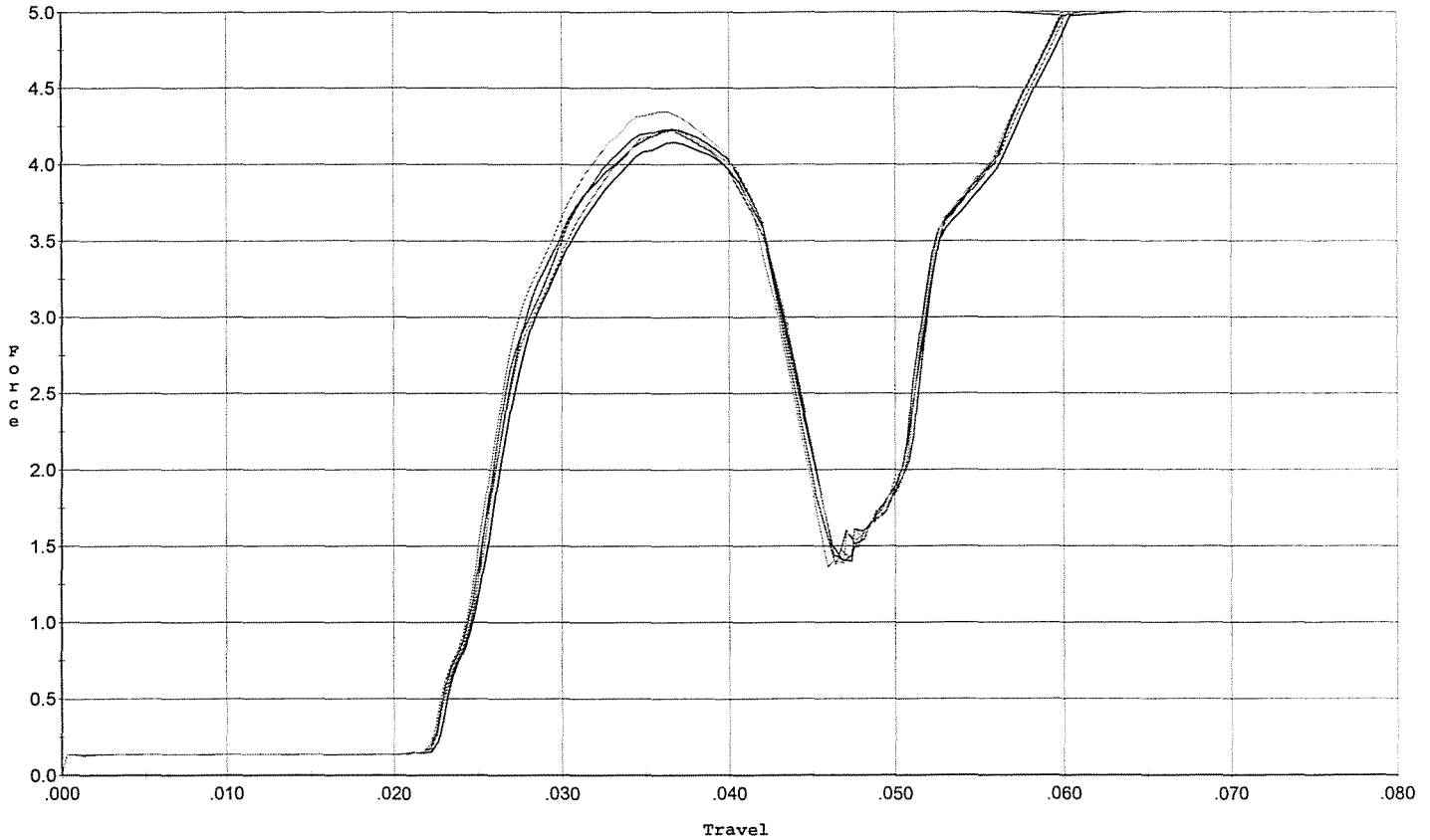
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.043	0.024	0.025	0.051		Set Trigger
2	3.288	0.041	0.024	0.025	0.051		Set Trigger
3	3.148	0.043	0.024	0.025	0.052		Set Trigger
4	3.145	0.042	0.024	0.025	0.050		Set Trigger
5	3.191	0.042	0.024	0.025	0.051		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



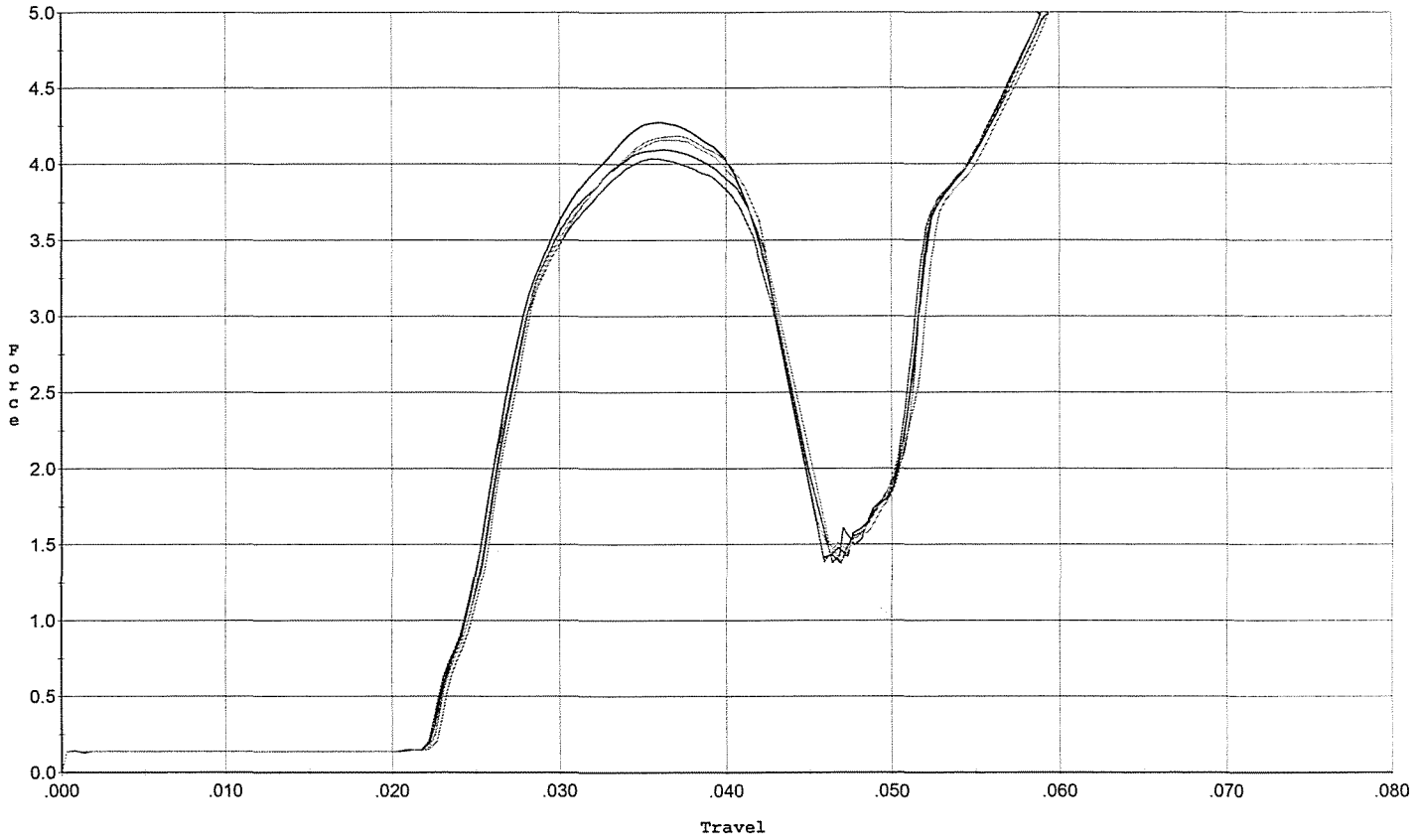
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.234	0.042	0.023	0.023	0.068		Set Trigger
2	4.146	0.044	0.023	0.023	0.070		Set Trigger
3	4.229	0.042	0.023	0.023	0.068		Set Trigger
4	4.347	0.043	0.022	0.023	0.071		Set Trigger
5	4.220	0.044	0.023	0.023	0.071		Set Trigger

A-4-23

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



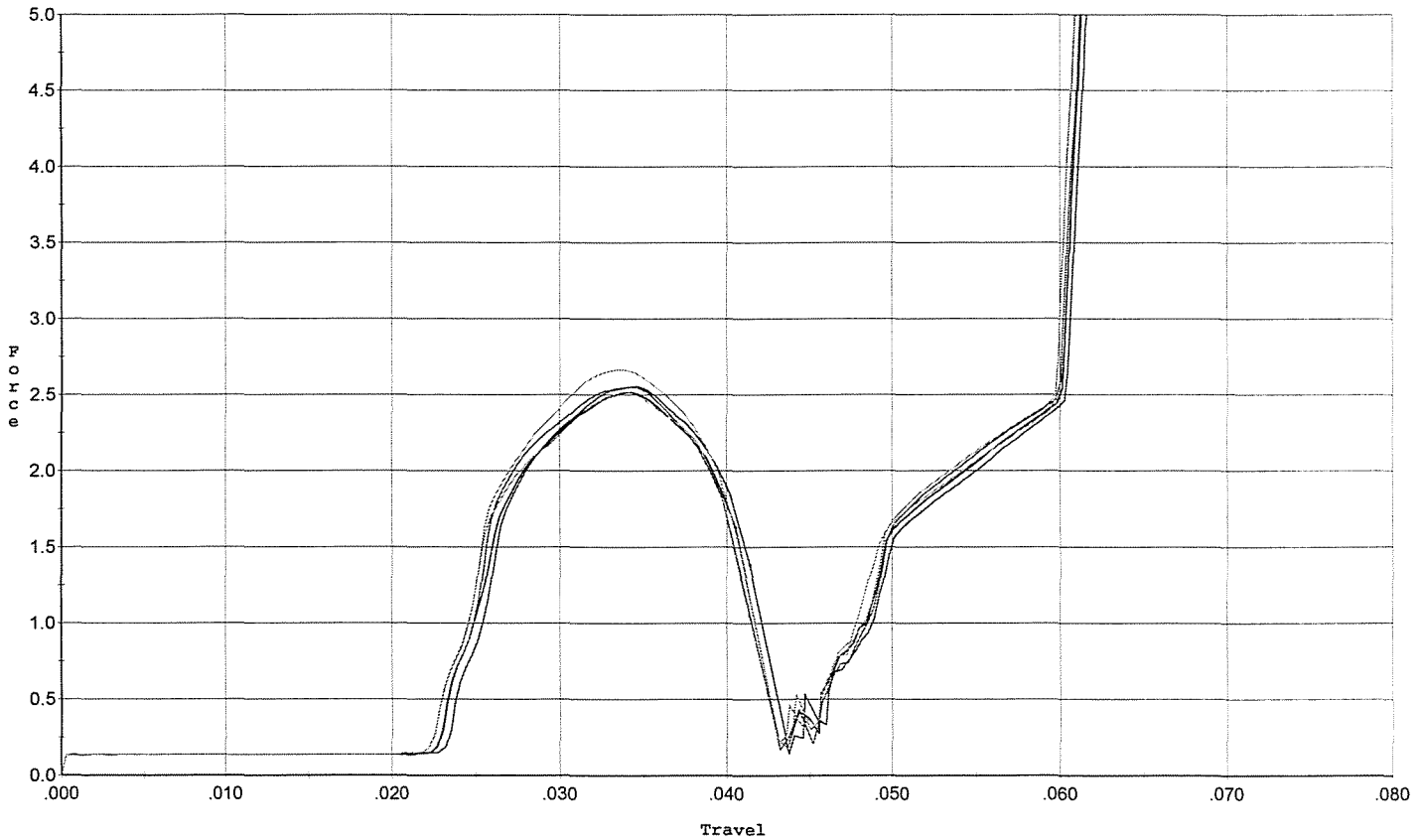
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.096	0.042	0.023	0.023	0.067		Set Trigger
2	4.274	0.042	0.023	0.023	0.070		Set Trigger
3	4.034	0.043	0.022	0.023	0.068		Set Trigger
4	4.159	0.042	0.023	0.023	0.068		Set Trigger
5	4.185	0.042	0.023	0.024	0.067		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs +/- .50 lb for final test



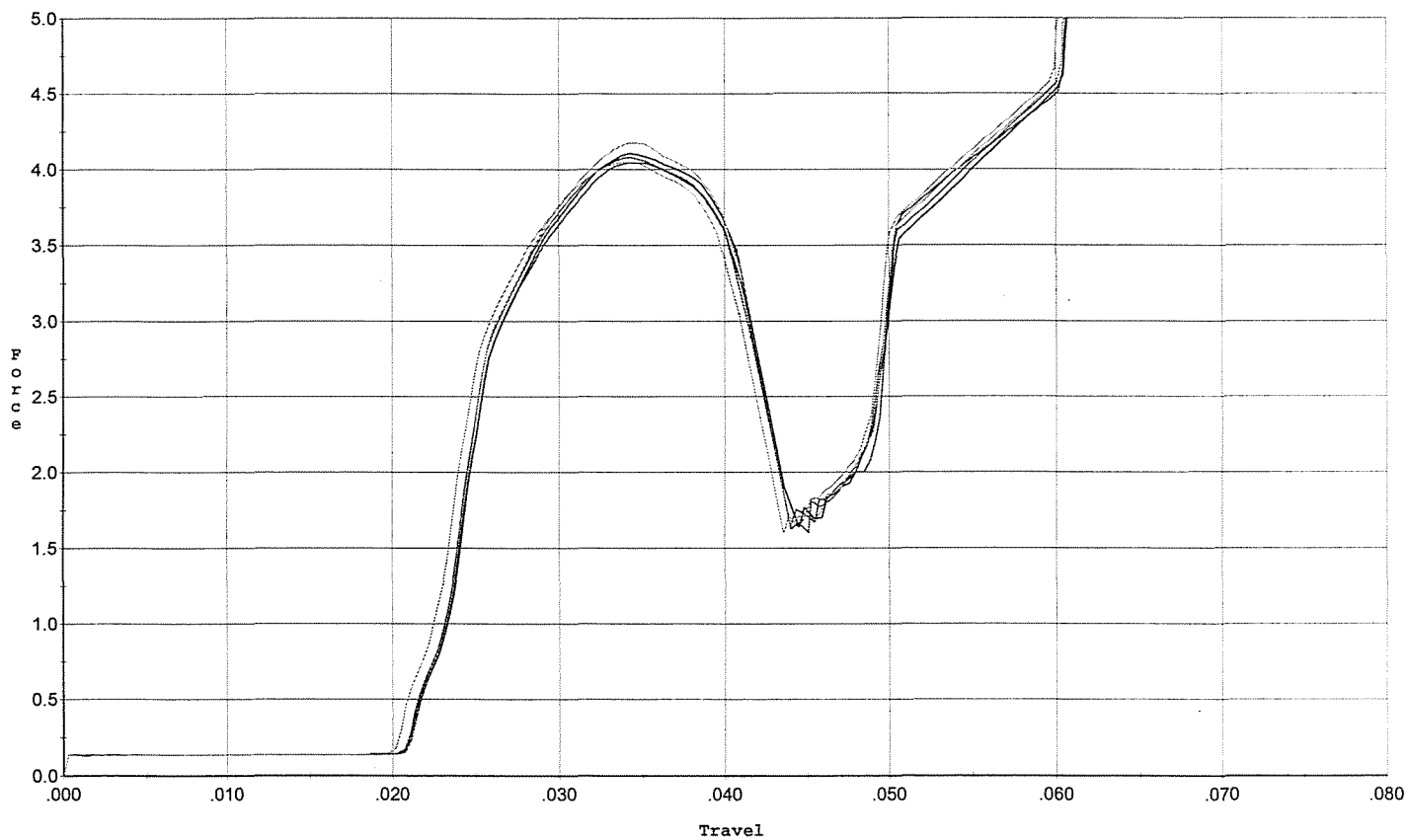
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.557	0.041	0.024	0.026	0.039		Set Trigger
2	2.519	0.041	0.023	0.026	0.038		Set Trigger
3	2.551	0.041	0.023	0.026	0.039		Set Trigger
4	2.665	0.041	0.023	0.025	0.041		Set Trigger
5	2.517	0.041	0.023	0.025	0.039		Set Trigger

A 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/18/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.047	0.041	0.021	0.023	0.066		Set Trigger
2	4.106	0.041	0.021	0.023	0.066		Set Trigger
3	4.081	0.042	0.021	0.023	0.068		Set Trigger
4	4.178	0.041	0.021	0.023	0.067		Set Trigger
5	4.049	0.041	0.021	0.023	0.067		Set Trigger

A. 4.09